

FIG.1

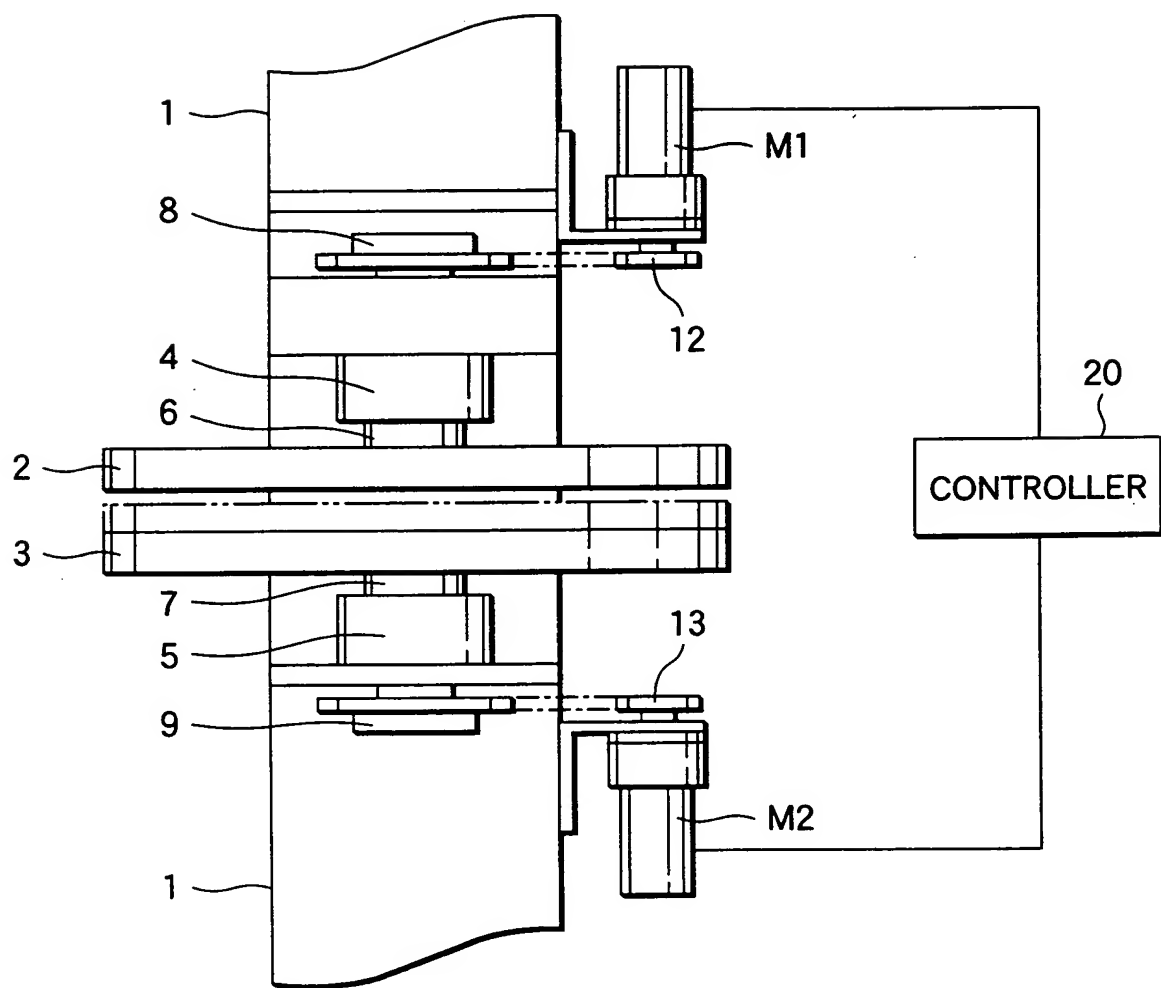


FIG.2A

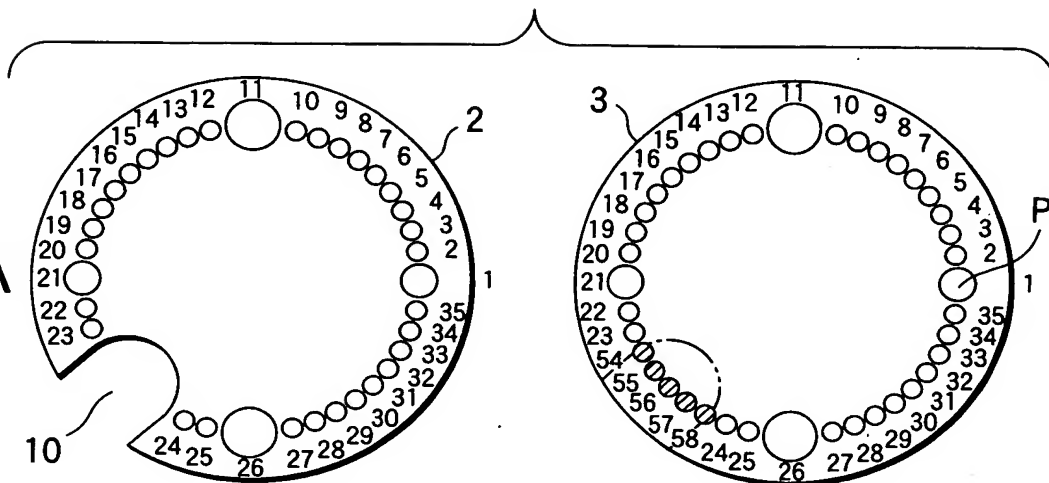


FIG.2B

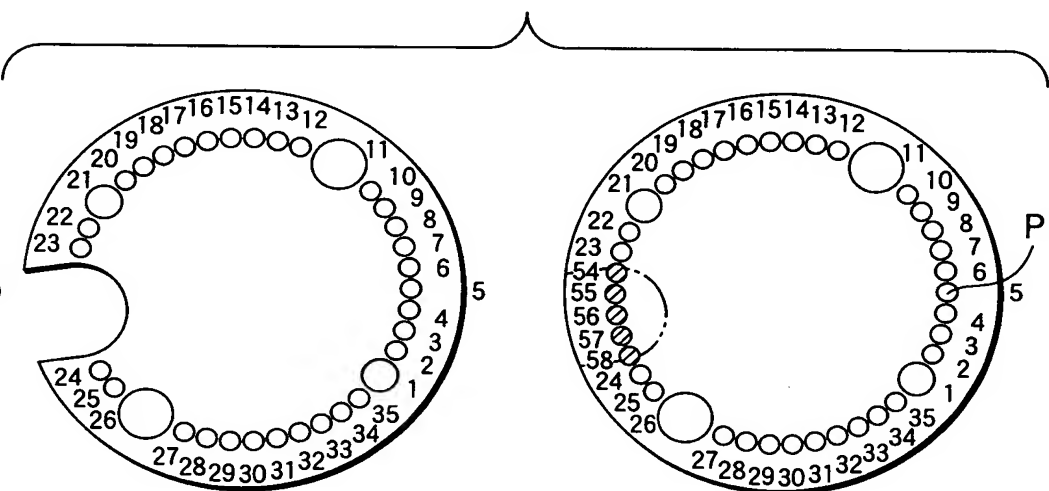
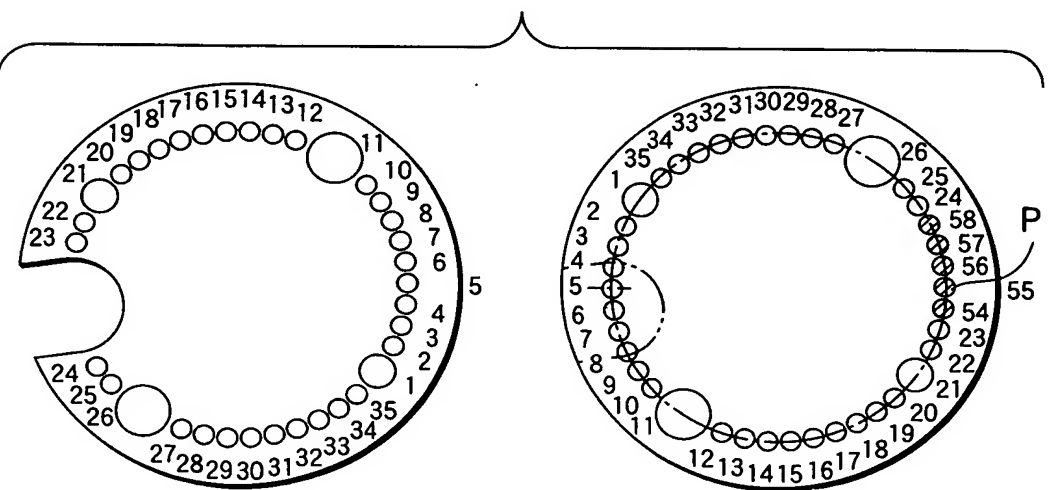


FIG.2C



2000

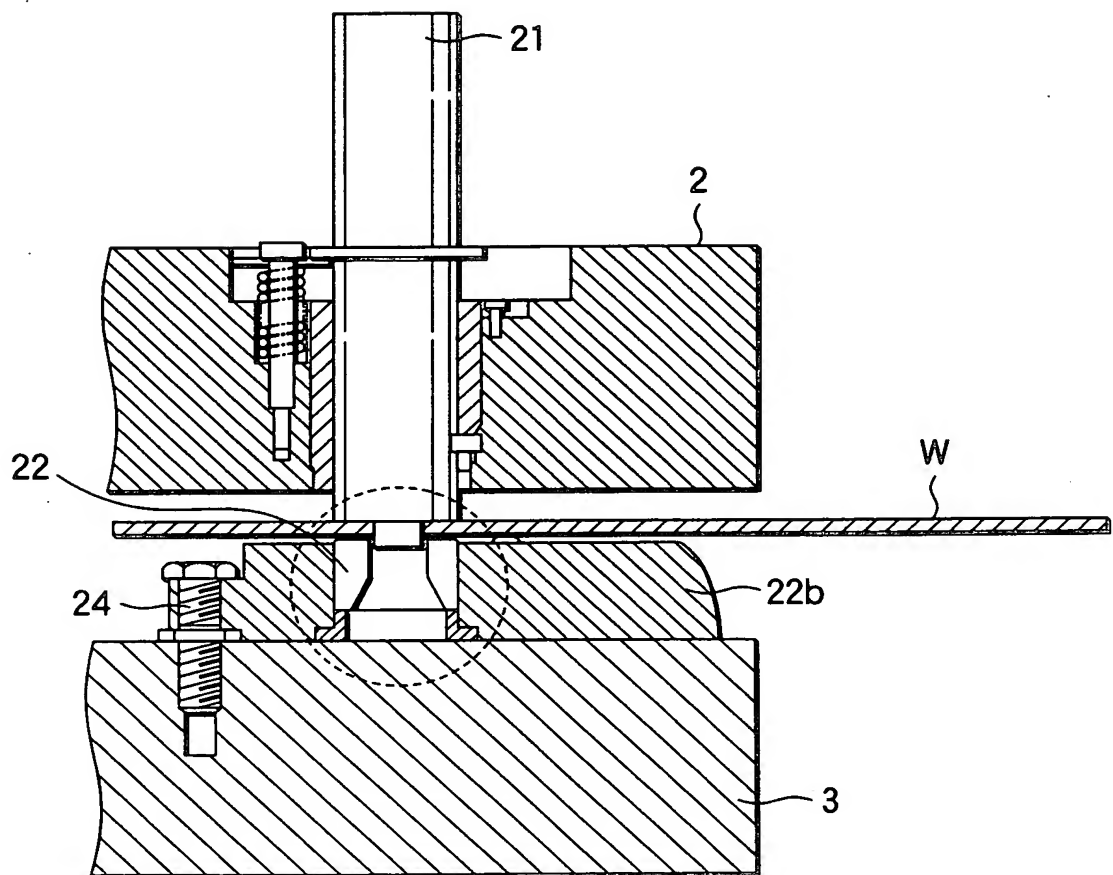
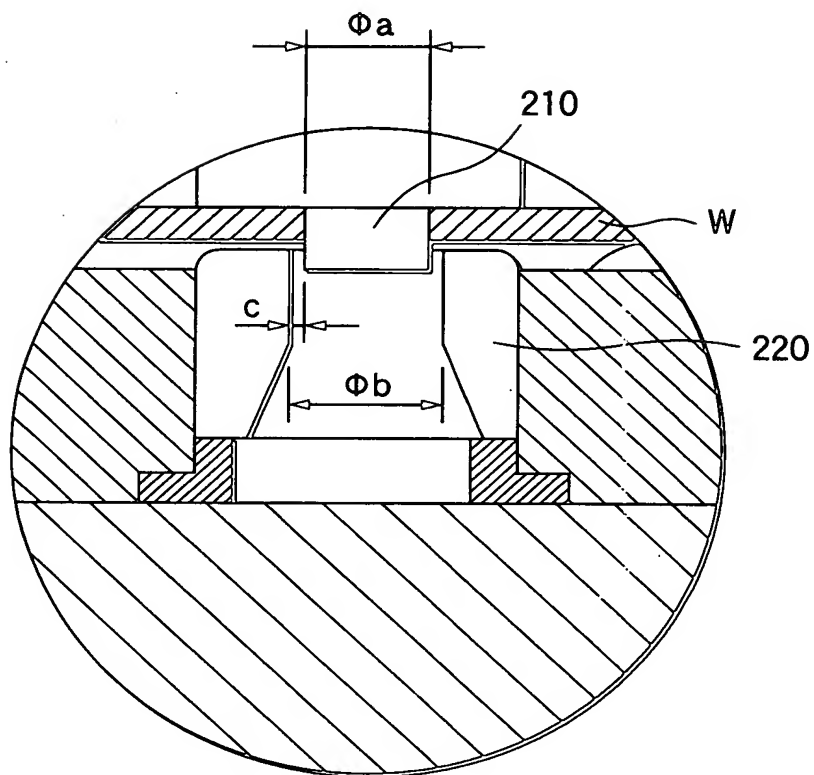


FIG.4



Φa : DIAMETER OF BLADE OF UPPER MOLD 210

Φb : DIAMETER OF HOLE OF LOWER MOLD 220

c : $(\Phi b - \Phi a) / 2$ (CLEARANCE)

FIG.5

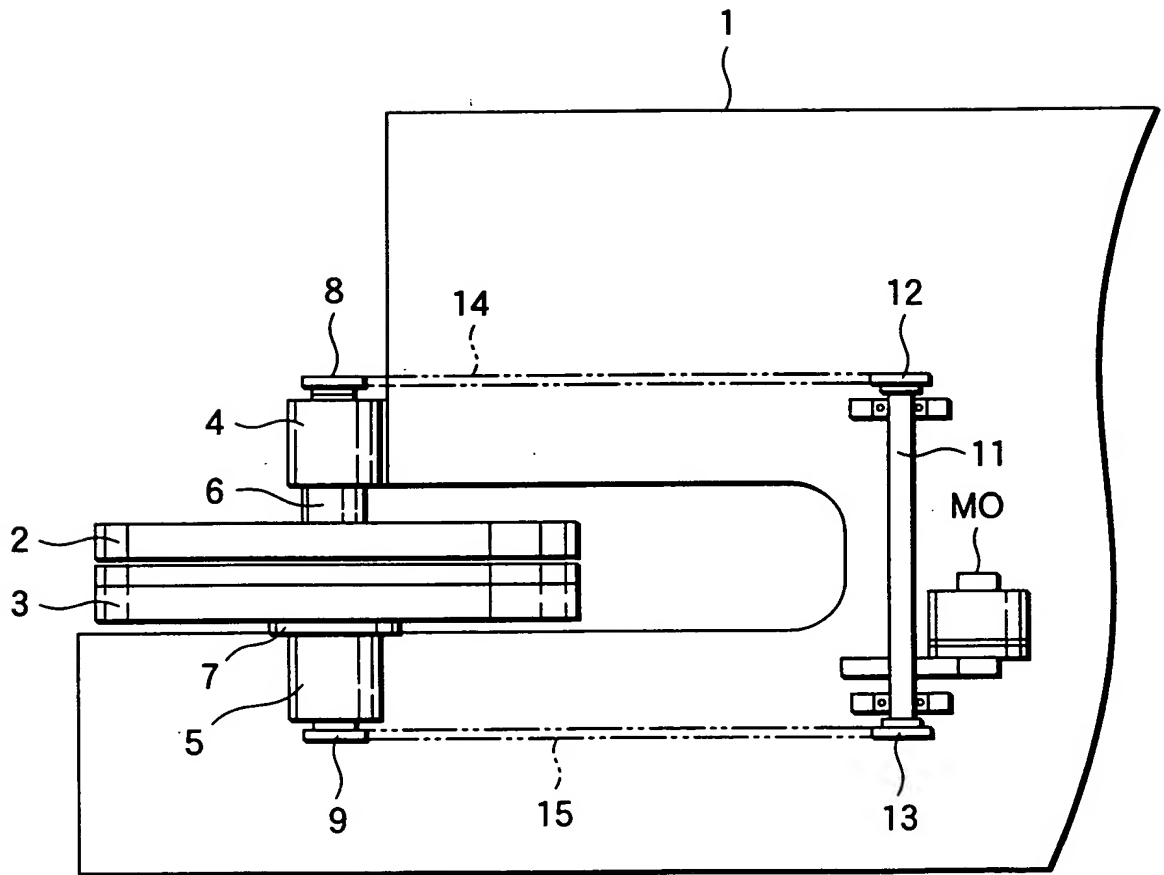


FIG. 6

